

Amendment under 37 C.F.R. §1.111  
U.S. Application No. 09/372,636  
Attorney's Docket No. 364/56

of heat flow relative to the remainder of the surface of the casting die providing increased cooling rate in the critically stresses areas the casting die.

2. (NOT CHANGED) The casting die body as recited in claim 1, wherein the form-giving casting die body is made of copper or a copper alloy.

3. (AMENDED) The casting die as recited in claim 1, ~~which includes further comprising~~ a die cavity ~~which is composed~~ having of two broad-side walls situated opposite each other and two narrow-side walls limiting the width of the billet forming a cross-section of the die cavity; said broad-side walls connected to a base and forming meniscus thereon.

4. (AMENDED) The casting die as recited in claim 3, wherein the cross-section of the die cavity at ~~the pouring-in-side~~ a first end is greater than at ~~the billet-exit-side~~ a second end.

5. (AMENDED) The casting die as recited in claim 3, wherein the die cavity  $\gamma$  at the ~~pouring-in-side~~ first end  $\gamma$  has at least one hollow space  $\gamma$  which can ~~become~~ becomes smaller in the ~~pouring direction (GR)~~ toward the second end.

6. (AMENDED) The casting die as recited in claim 1, wherein the cooling zone having a greater surface-related heat flow is arranged in ~~the~~ a bath surface area, the cooling zone extending to at least 20% of the length of the meniscus of the broad-side wall.

7. (AMENDED) The casting die as recited in claim 6, wherein the cooling zone having a greater surface-related heat flow is arranged in ~~the~~ a bath surface area, the cooling zone extending to 30-60% of the length of the meniscus of the broad-side wall.

8. (NOT CHANGED) The casting die as recited in claim 1, wherein the surface-related heat flow in the more stressed area of the bath surface is 5-40% greater than in the other areas of the bath surface.

9. (NOT CHANGED) The casting die as recited in claim 8, wherein the surface-related heat flow in the more stressed area of the bath surface is 10-20% greater than in the other areas of the bath surface.

10. (AMENDED) The casting die as recited in claim 1, wherein the wall thickness separating the die from the bath is reduced in thermally and mechanically stressed areas of the broad-side walls ~~between the pouring and cooling surface is~~

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~~reduced in the thermally and mechanically stressed areas of  
the broad-side walls.~~

11. (AMENDED) The casting die as recited in claim 10,  
wherein the wall between the pouring and the cooling surface  
~~in~~ of the bath surface area has a thickness that is reduced by  
1 to 6 mm.

12. (AMENDED) The casting die as recited in claim 1,  
wherein the casting die body ~~has~~, in a direction running  
parallel to the direction from the first end to the second end  
~~pouring direction~~ further comprises ~~a~~ at least one groove-  
shaped coolant channel or cooling bore holes, which in the  
thermally and mechanically stressed areas are configured  
narrower than in other areas.

13. (AMENDED) The casting die as recited in claim 12,  
wherein the spacing of the coolant channels or cooling bore  
holes in the thermally and mechanically stressed areas is at  
least 20% less than in the horizontal ~~adjoining~~ adjacent areas  
of the bath surface.

14. (NOT CHANGED) The casting die as recited in claim  
12, wherein the coolant channels or the cooling bore holes are  
arranged in a transitional area so as to become gradually  
narrower.